



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3179-041
Job Sheet 209109



Part No: D3179-041

Job Qty: 4 pcs

Part Name: Litter Tie Down (Non-Locking)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/14/20

Job Tracking No:

Due Date: 5/8/20

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *SKL*

Description:

Note: DWG REV E IPP A1 03.01.09 Added Acid etch end alodine RF IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP REV:C AS PER REV D JLM 13-05-24 VERIFIED BY:DD IPP Rev:C 08-12-10 add part list DD verified
by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	4 pcs			0.00	0.33	Bandsaw - 1			SS 20-04-29
110	HAAS 4 Axis - B4B	4 pcs			0.37	7.27	HAAS - 1 - B4B			SS 20-04-29
							HAAS - 2 - B4B			
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
120	QC 2	4 pcs			0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			SS 20-04-29
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			



DART
AEROSPACE

Container No: S274964



Part: D3179 - 041
Job No: 209109
Serial No/Batch: S274964
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/03/20



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Date: 05/03/20

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			QC 2 - 62	
			QC 2 - 63	
			QC 2 - 8	
			QC 2 - 66	
			QC 2 - 64	
			QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 2 - 86	
			QC 2 - 83	
			QC 8 - 12	
			QC 8 - 14	
130 QC 8	4 pcs	0.00 0.00	QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	mark 20/05/03
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	0.00 0.32	Handfinish - 1 - 1 - B4B	BEB 20-05-05
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	

https://www.plexonline.com/4fe9d4f3-2d3c-4600-bcee-f8866cda5007/Plexus_Control/Report_View_2.asp?URL=../Part/Job_Sheet.asp&Report=True... 3/5

			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
			QC 3 - 87	
180 Small Fab - 2 - B4B	4 pcs	0.00 0.60	Small Fab - 1 - B4B	DAS MAY 08 2020 58 9-89
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
190 QC 5	4 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81 QCS-82	DAS 82 9-89 MAY 11 2020
200 Packaging 3-1 - Stock - B4B	4 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	DAS 28 9-89
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
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			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	

			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
210 QC 21 - SA	4 pcs	0.00 0.00	QC 21 - SA - 21	OAS
			QC 21 - SA - 70	MAY 11 2020 70
			QC 21 - SA - 53	9-89

Part Op 100 - (Bandsaw) Cut blanks: 12.150" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA297 Rev: 44 & Dwg D3179-1 Rev: E
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Small Fab) Assemble as per Dwg D3179
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	4.0500 ft (1.0125 ea)	100-Bandsaw - 1	5229 069 → 4.100'
D2372	Quick Release	8 pcs (2 ea)	180-Small Fab - 2 - B4B	523174X3 524678X5
D2444	Pip Pin Assembly	4 pcs (1 ea)	180-Small Fab - 2 - B4B	5244097 5197825
MS21042L3	Nut	4 Ea (1 ea)	180-Small Fab - 2 - B4B	5260063
MS27039-1-13	Screw	4 Ea (1 ea)	180-Small Fab - 2 - B4B	5006972
NAS1149D0332J	Washer	12 Ea (3 ea)	180-Small Fab - 2 - B4B	5248042 - 1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6201	4	23	0
180-Small Fab - 2 - B4B	D2372	8	18	0
	D2444	4	11	0
	MS21042L3	4	2,307	0
	MS27039-1-13	4	236	0
	NAS1149D0332J	12	2,308	0

Part Specifications

Specifications could not be found.

Plex 4/14/20 11:34 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 209109
Description: Fwd Litter Tie Down Bracket		Part Number: D3179-1
Inspection Dwg: D3179 Rev: E		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.010	✓		SLIO	Vern
R0.40	+/-0.030	.400	✓		Rad gauge	
R0.38	+/-0.030	.380	✓		"	
1.70	+/-0.030	1.700	✓		SLIO	Vern
Ø0.191	+0.005/-0.001	.192	✓			
10.500	+/-0.010	10.500	✓			
4.250	+/-0.010	4.250	✓			
Ø0.246	+0.005/-0.001	.245	✓			
1.50	+/-0.030	1.506	✓			
0.750	+/-0.010	.746	✓			
1.000	+/-0.010	.995	✓			
4.00	+/-0.030	3.996	✓			
1.00	+/-0.030	.998	✓		Height gauge (31006)	
1.38	+/-0.030	1.381	✓			
1.875	+/-0.010	1.873	✓			
2.125	+/-0.010	2.122	✓			
2.88	+/-0.030	2.870	✓			
3.31	+/-0.030	3.312	✓			
R0.375	+/-0.010	.375	✓		Rad gauge	
R0.50	+/-0.030	.500	✓		"	
Ø0.191	+0.005/-0.001	.192	✓		gauge Pin	
R0.25	+/-0.030	.250	✓		Rad gauge	
R0.375	+/-0.010	.375	✓		"	
R0.38	+/-0.030	.380	✓		"	
12.00	+/-0.030	12.002	✓		SLIO	Vern
9.000	+/-0.010	9.001	✓			
7.50	+/-0.030	7.495	✓			
4.50	+/-0.030	4.510	✓			
2.88	+/-0.030	2.877	✓			
2.250	+/-0.010	2.250	✓			
1.000	+/-0.010	1.002	✓			
0.50	+/-0.030	.501	✓			

Measured by: 20 2-89	Checked by: Jmm	QC Inspector:
Date: 20-04-29	Date: 20/05/63	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue P/O D3179-041	KJ/DD	
B	12.10.04	Dimension 0.750 was 1.750	KJ	
C	13.05.27	Dimensions revised per Dwg Rev D	KJ	
D	16.06.08	Dimensions revised per Dwg Rev E	KJ	
E	17.02.16	Dimensions rearranged	KJ	

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Eng. (Non-AW) ☐ Machining ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Rec/Store/Packaging ☐ Finishing ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	MRB (QS1042)																																																									
Date: _____ Sequence #: _____ QTY Affected: _____		Disposition																																																											
Description Work Order Deviation																																																													
Root Cause <table style="width: 100%;"> <tr> <td>Operator</td><td>☐</td></tr> <tr> <td>Manufacturing Process</td><td>☐</td></tr> <tr> <td>Equip/Tooling</td><td>☐</td></tr> <tr> <td>Handling/Preservation</td><td>☐</td></tr> <tr> <td>Material</td><td>☐</td></tr> <tr> <td>Product Improvement</td><td>☐</td></tr> <tr> <td>Process Improvement</td><td>☐</td></tr> <tr> <td>Human Factors</td><td>☐</td></tr> </table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY																																											
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